

Work Order ID 63120

Thursday, October 21, 2010 1:29:46 PM

Page 1

Item ID: D3529-1

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 10/21/2010 Start Qty: 8.00

Required Date: 10/28/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date: 10-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3529

Rev A

110

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3529-1BLANK

BIO-10-25

(8)

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining 2-Machine as per
Folio FA645 and Dwg D3529 3-Deburr

B.A./JL

10/11/15

(8)

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A./JL

10/11/15

8

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3529-1

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 10/21/2010 Start Qty: 8.00

Required Date: 10/28/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

AMK 10/11/16

Quality Control

2 0

150

Identify as per dwg & Stock Location: PPP

0.00



Packaging

Memo

63149

0.00

Packaging

10/11/16 (8)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/16

MF

10-11-16

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Picklist Print

Thursday, October 21, 2010 1:29:50 PM

Page 1

Work Order ID: 63120

Parent Item: D3529-1

Parent Item Name: Bearpaw



Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-28 JLM
IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

100

sf

24.3060

1.265

10.65263



UHMW 1" Black



1810-10-25

Location

Loc Qty

Loc Code

MAT

24.306

114624

8.8

115325

15.506

115955

118958

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DART AEROSPACE LTD		Work Order:	63128
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.504	✓		vern JL-3	
B	0.07 x 45°	+/-0.030 x 0.5°	0.065 x 45°	✓			
C	R0.25	+/-0.030	0.250	✓		R-G	
D	0.250	+/-0.010	0.252	✓		mic JL-4	
E	0.625	+/-0.010	0.626	✓		vern JL-3	
F	0.950	+/-0.010	0.952	✓			
G	1.63	+/-0.030	1.620	✓			
H	12.14	+/-0.030	12.140	✓		m-tape	
I							
J	5.70	+/-0.030	5.695	✓		vern JL-3	
K	0.375	+/-0.010	0.377	✓			
L	0.525	+/-0.010	0.525	✓		mic CNC 118-120	
M	0.13 x 45°	+/-0.030 x 0.5°	0.130 x 45°	✓			
N	R0.50	+/-0.030	0.500	✓		R-G	
O	12.76	+/-0.030	12.76	✓		m-tape	
P	3.38	+/-0.030	3.375	✓		vern JL-3	
Q	3.75	+/-0.030	3.753	✓			
R	5.187	+/-0.010	5.187	✓			
S	5.25	+/-0.030	5.250	✓			
T	7.13	+/-0.030	7.125	✓		H-G	
U	Ø0.260	+0.006/-0.001	Ø0.259	✓		Vern	Vern GA-01
V	0.30	+/-0.030	0.310	✓		D-G	GA-08
W	0.93	+/-0.030	0.923	✓		Vern	GA-01
X	1.30	+/-0.030	1.30	✓		vern JL-3	

Measured by:	JL
Date:	10/11/15

Audited by:	EWL
Date:	10/11/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

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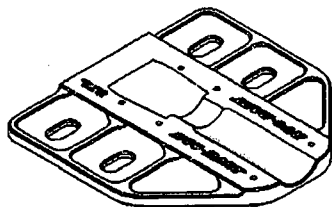
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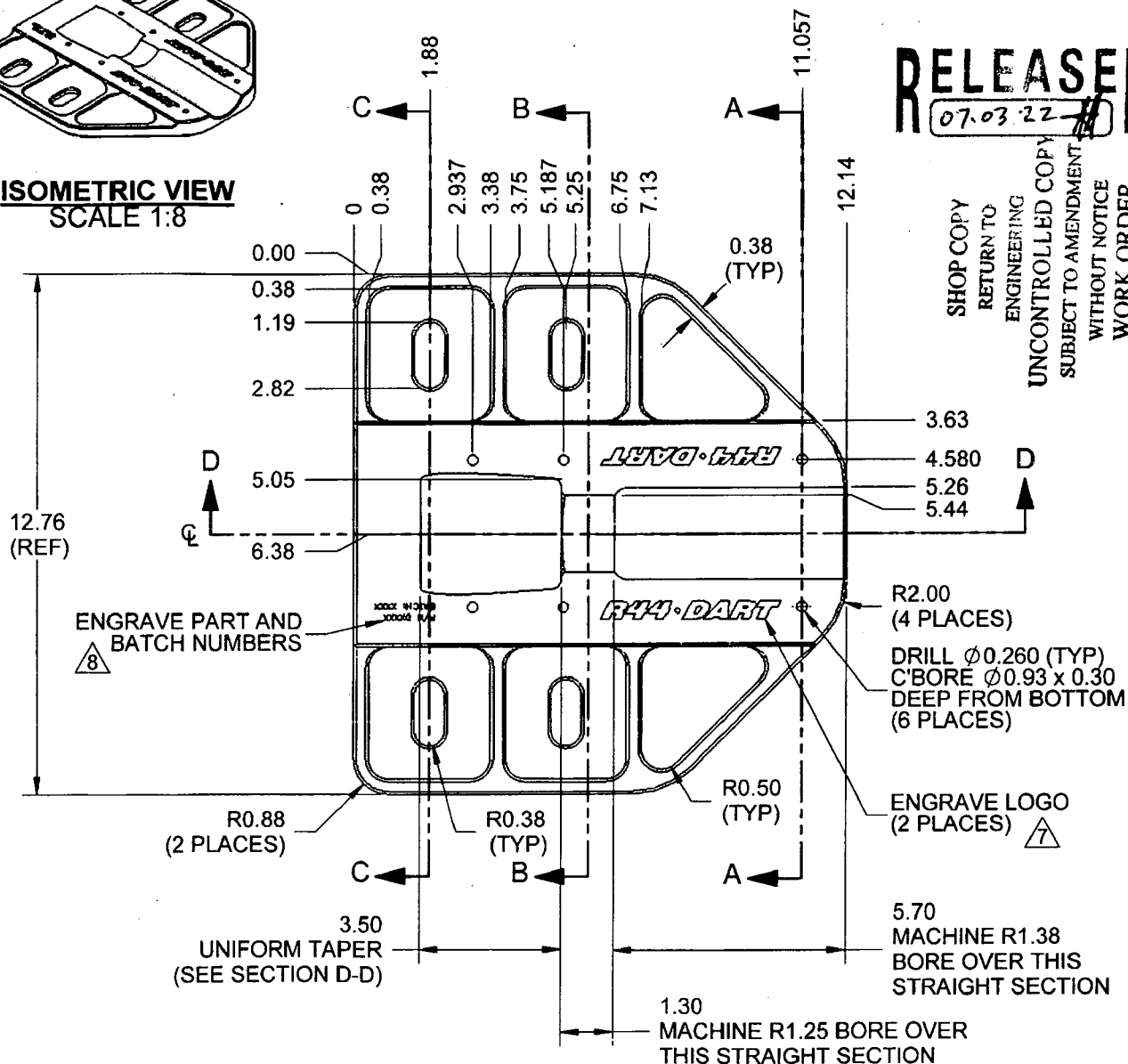
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04	TITLE R44 BEARPAW	SCALE 1:4	
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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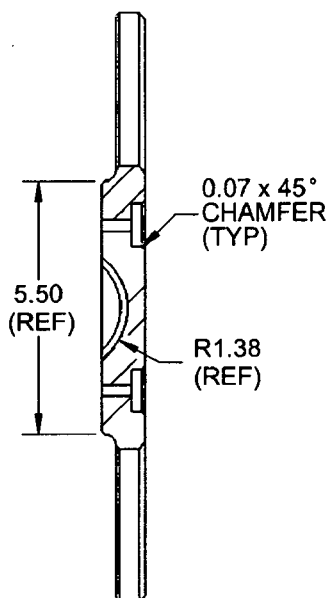
NOTE: Date & initial all entries



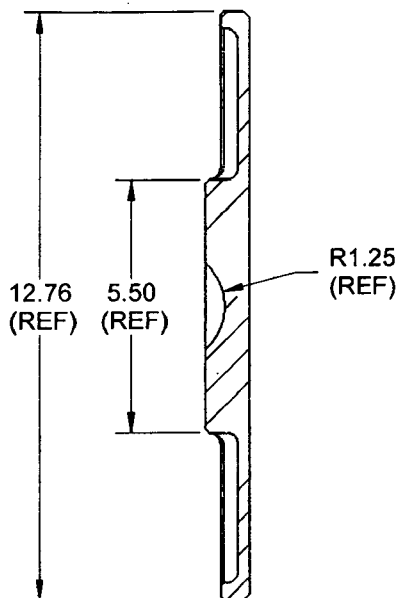
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
07.03.22

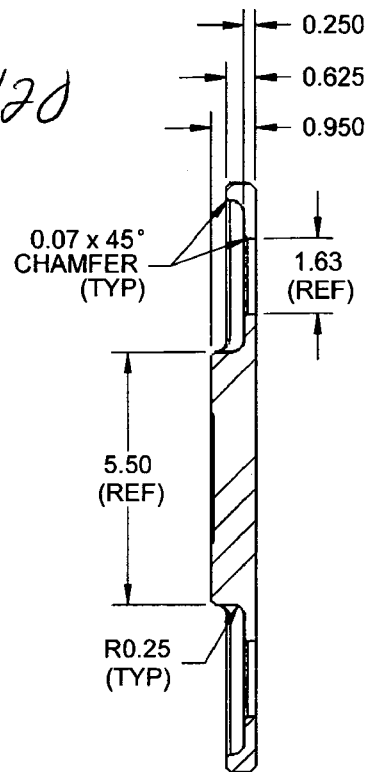
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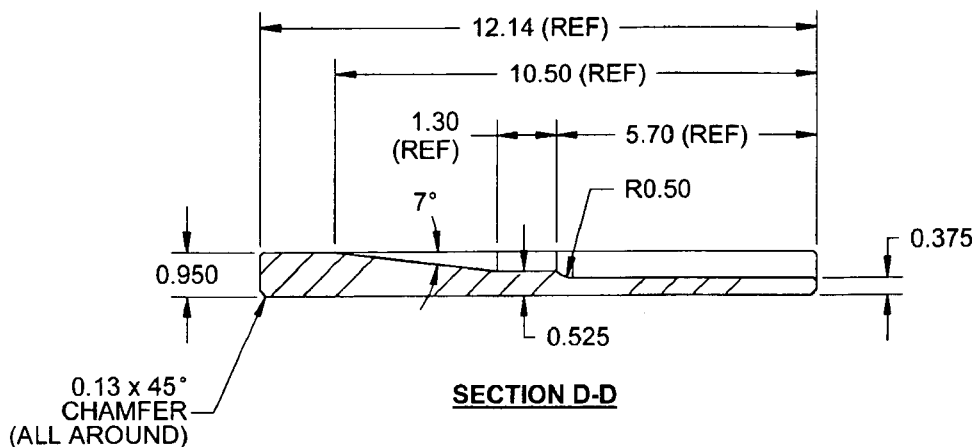
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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